

#### ABSTRACT OF THE DISCLOSURE

A method of making a ceramic shell mold comprises repeatedly coating a fugitive pattern of an article to be cast with a ceramic slurry layer and applying on the ceramic slurry layer a refractory stucco to form a plurality of ceramic slurry layers and stucco layers on the pattern wherein at least one of the stucco layers is formed by applying discontinuous stucco fiber bundles held together in the bundles by a fugitive binder, which is removed during subsequent firing of the shell mold at elevated temperature.